

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012576**Date Inspected:** 12-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Bay 1:

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of OBG component – Traveler Rail; weld joint 20TR1-004 – 003. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Yang Fu Zhi. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

FCAW of OBG component – Traveler Rail; weld joint 20TR1-025 – 001 & 003. Welder is identified as 250672. ZPMC Quality Control (QC) is identified as Zhou Yu Long. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

FCAW of OBG component – Traveler Rail; weld joint 20TR1-040 – 001 & 005. Welder is identified as 059450. ZPMC Quality Control (QC) is identified as Dong Yi Qun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW of OBG component – Traveler Rail; weld joint 20TR2-021 – 011. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Liu Yang Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

Bay 7:

This QA Inspector observed the following work in progress:

Repair welding of OBG component – Traveler Rail 11TR3-021 - 010. Welder is identified as 049769. Welding process is identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) is identified as Cui Jun Jie. The repair welding was carried out as per Welding Repair Report (WRR) report no: B-WR-10540 R-0 (UT report no: B787-UT-11104). The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-1G (1F)-Repair.

Repair welding of OBG component – Traveler Rail 10TR2-004 - 014. Welder is identified as 053742. Welding process is identified as FCAW. ZPMC Quality Control (QC) is identified as Cui Jun Jie. The repair welding was carried out as per Welding Repair Report (WRR) report no: B-WR-10314 R-0 (UT report no: B787-UT-10797). The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-2G (2F)-Repair-1.

Bay 8:

This QA Inspector observed the following work in progress:

Submerged Arc welding (SAW) of side panel for Cross Beam (CB) 17, weld joint CB3001D-017- 002. Welder is identified as 040831. ZPMC Quality Control (QC) is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-B-L2C-S2.

Bay 15:

CB5:

Notification No: 005318.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT reports for this date. The member is identified as CB5. The weld designations reviewed are as follows:

- 1) CB202G-009 – 089/090, 095/096.
- 2) CB202G-012 – 117/118, 119/120.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh
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Quality Assurance Inspector

Reviewed By:	Hall,Steven
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QA Reviewer
